

Work Order ID 70463

Thursday, June 09, 2011 7:41:58 AM



Page 1

Item ID: D3536-13

Accept



Setup Start



Revision ID:

Item Name: Gasket

Stop



Start Date: 6/9/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: ✓

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3536	Rev A

100



FLOW WATER JET

Waterjet

FLOW CNC Waterjet

Memo

I-Cut as per Dwg D3536 Dwg Rev: A Prog Rev: K 12-
Deburr if necessary

B11-6-9

(12)

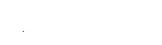
110



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control



Memo

0.00

B11-6-9

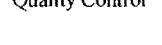
120



QC8- Inspect parts - second check

QC

Quality Control



Memo

0.00

S 106102

(12)

Work Order ID 70463

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Item ID: D3536-13

Accept



Setup Start



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Item Name: Gasket

Stop



Start Date: 6/9/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Picklist Print

Page 1

Thursday, June 09, 2011 7:41:55 AM

Work Order ID: 70463



Parent Item: D3536-13



Parent Item Name: Gasket

Start Date: 6/9/2011

Required Date: 6/10/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-I4 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063 		Purchased	No			100	sf	100.6800	0.8269	11.02533 			RB11-6-9

NEOPRENE SHEET 0.063

Location	Loc Qty	Loc Code
MAT052	100.68	
117295	100.68	

117295

(12)

DART AEROSPACE LTD	Work Order:	70463
Description: Gasket	Part Number:	D3536-13
Inspection Dwg: D3536	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

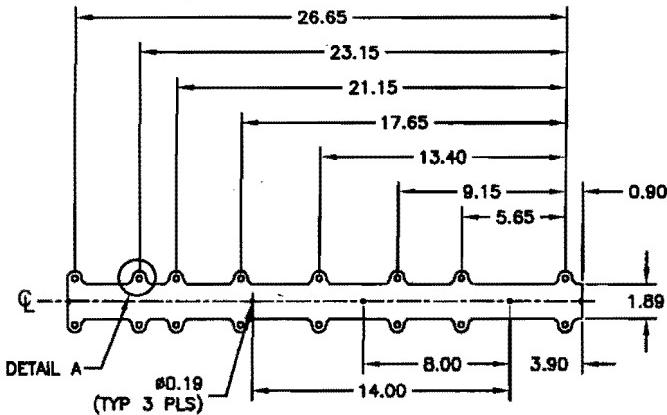
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
32.90	+/-0.030	32.90	✓		T	IB01
29.40	+/-0.030	29.40	✓		T	
27.40	+/-0.030	27.40	✓		T	
23.90	+/-0.030	23.90	✓		T	
18.98	+/-0.030	18.98	✓		T	
14.07	+/-0.030	14.07	✓		T	
9.15	+/-0.030	9.15	✓		T	
5.65	+/-0.030	5.65	✓		T	
3.90	+/-0.030	3.90	✓		T	
8.00	+/-0.030	8.00	✓		T	
14.00	+/-0.030	14.00	✓		T	
20.00	+/-0.030	20.00	✗		T	
1.89	+/-0.030	1.886	✗		T	
0.30	+/-0.030	.309	✗		✓	IB02
0.30	+/-0.030	.305	✗		✓	
Ø0.19	+0.005/-0.001	.190	✗		✓	

Measured by:	B	Audited by:	S	Prototype Approval:	N/A
Date:	11-6-09	Date:	11/06/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.06.13	New Issue	KJ/JLM	E

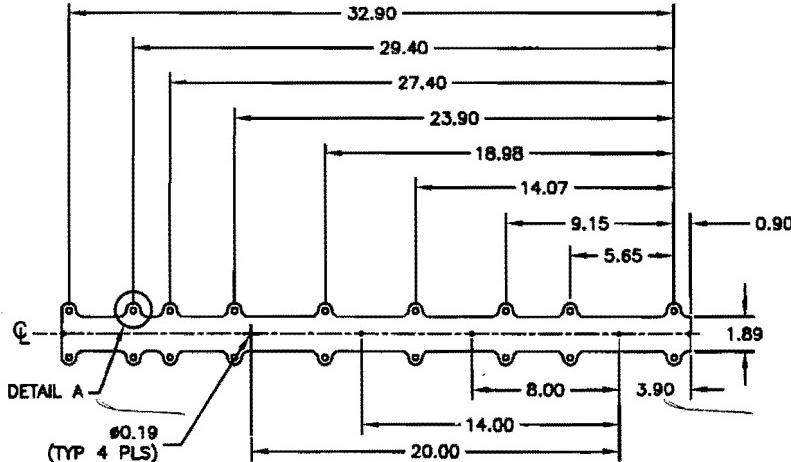
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D3536-11 GASKET

- WB 10/16/03*
- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK. 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
 - 2) FINISH: NONE
 - 3) PART IS SYMMETRICAL ABOUT $\frac{Q}{2}$
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
 - 7) SEE PAGE 6 FOR DETAILS AND SECTION



D3536-13 GASKET

RELEASED
09.02.02

DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>PH</i>	APPROVED <i>SH</i>	DRAWING NO. D3536
DATE 06.10.25		TITLE GASKET
A	06.10.25	NEW ISSUE
		REV. A SHEET 1 OF 6 SCALE 1:10